

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023893**Date Inspected:** 22-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Shi Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 009211

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 13AW. The weld designations reviewed are as follows:

1. SEG3013L-097, 096, 092, 094, 099, 088, 093
2. SEG3013J-066, 064
3. SEG3013AA-068, 075, 082, 089, 096, 103, 110, 117, 124
4. SEG3013AA-005, 012, 019, 026, 033, 040, 047, 054, 061
5. SEG3013N-037
6. SEG3013E-253
7. SEG3013Q-194, 210, 106, 107, 108, 109
8. DP3120-001-012, 011, 020, 017

OBG Trail Assembly Yard

This QA Inspector observed the following work in progress:

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Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3014C-130, 126 and 122 located on side plate I-rib to floor beam at panel point 122 of OBG Segment 13BW. ZPMC Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21062.

SMAW welding of weld joint SEG3014L-091, 116 and 131 located on side plate I-rib to floor beam at panel point 122.5 of OBG Segment 13CW. ZPMC Welder is identified as 057220. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21062.

SMAW welding of weld joint SEG3014N-098 located on RS Stiffener to Floor Beam at panel point 121.5 of OBG Segment 13BW. ZPMC Welder is identified as 040614. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3014N-070 located on RS Stiffener to Floor Beam at panel point 121 of OBG Segment 13BW. ZPMC Welder is identified as 069075. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint DP3135-001-030 and DP3148-001-241 located on Longitudinal Diaphragm to Deck Panel of OBG Segment 13B/CW. ZPMC Welder is identified as 069075. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21033.

SMAW welding of weld joint DP3133-001-030 and DP3146-001-241 located on Longitudinal Diaphragm to Deck Panel of OBG Segment 13B/CW. ZPMC Welder is identified as 051220. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21033.

Flux Core Arc Welding (FCAW) welding of weld joint SA7514-004- 002 and 005 located on corner assembly connected SA7514 at panel point 121.5 FL2 side of OBG Segment 13BW. ZPMC Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer